

Work Order ID 58661

Thursday, May 13, 2010 10:28:09 AM



Page 1

Item ID: D3914-041

Accept



Setup Start



Revision ID:

Item Name: Long Basket Lid Assembly (350)

Stop



Start Date: 5/13/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/19/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 10-5-13 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop


**Sequence ID/
Work Center ID**
**Operation
Description**
**Set Up/
Run Hours**
**Draw
Number**
**Draw
Rev.**
**Plan
Code**
**Accept
Qty**
**Reject
Qty**
**Reject
Number**
**Insp.
Stamp**
Draw Nbr **Revision Nbr**

D3914

A



Large Fab

Memo

0.00

Large Fab

1- assemble ribs , weld as per dwg D3914 using DT9607A
 2- weld hinge (3) and Mounting brackets as per dwg D3914
 inspect before welding mesh
 3- tack weld mesh on basket as per dwg D3914
 ***make sure to place mesh correctly on lid, check with label plate before
 tacking mesh***

PL 10-05-25

110



QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

PL 10-05-25

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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC5- Inspect part completeness to step on W/O

Set Up/
Run Hours

0.00

S wls/b5

Draw
Number Draw
Rev. Plan
Code Accept
Qty Reject
Qty Reject
Number Insp.
Stamp

130



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

1112588

Memo

0.00

Start: 8:00AM

Fin: 320%

0.00

Temp: 8:30AM

140



HandFinish

Hand Finishing

Wing Walk as per dwg QSI005 4.4 Batch

11144132

Memo

0.00

1- Mask data plate and apply wing walk on outside surface of mesh as per dwg

2- Install placard and label as per dwg

D E510/05/26 ①

① BK 10-5-26.

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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

150



QC

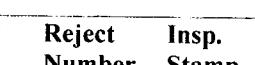
Quality Control

Operation
Description

QC3- Inspect Part Finish

Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

E5/10/2010

160



Packaging

Packaging

Identify as per dwg & Stock Location: G-A

0.00

*w/o
B58777*

Memo

0.00

E5/10/2010

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/05/2010

C2105124

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Picklist Print

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Work Order ID: 58661



Parent Item: D3914-041



Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 5/13/2010

Required Date: 5/19/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

3

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

D2581



Mounting Bracket

Manufactured

No

100

Each

36.0000

2



GPL 10.05.21

Location Loc Qty Loc Code

WA

36

46086

2

51745

2

57185

9

58301

23

D2728-3



Manufactured

No

140

Each

0.0000

1



88 10/05/21

(2)

Dart Logo label

D3914-1



Manufactured

No

100

Each

6.0000

2



Rib

Location Loc Qty Loc Code

WA

6

58241

2

58585

4

D3914-7



Manufactured

No

100

Each

4.0000

2



Rib

Location Loc Qty Loc Code

WA

4

58242

4

B58617 → 2

GPL 10.05.21

(2)



B58707 → 2

(2)

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Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D4016-3 		Manufactured	No			100	Each	19.0000	3		<i>PL 10.05.21</i>	

Hinge Half, Lid

Location	Loc Qty	Loc Code
ST109	7	<i>58595 → ①</i>
57574	7	

ST116	12	
58243	12	<i>②</i>

Rib

Location	Loc Qty	Loc Code
WA	12	
58244	12	

D4020-5

Mesh (350 Basket Long, Lid)

Location	Loc Qty	Loc Code
WA	12	
58244	12	

WA	2	
58244	2	

D4021-3

Data Plate

Location	Loc Qty	Loc Code
WA	2	
58245	2	

WA	3	
56050	1	
58246	2	

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Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

D4035-041		Manufactured	No		100	Each	2.0000	1				
-----------	--	--------------	----	--	-----	------	--------	---	--	--	--	--

Lid Rib Assembly, Fwd (350 Basket)

Location Loc Qty Loc Code

WA 2

58192 2

100 Each

2.0000 1

CPL 10-05-21

B 58743 → ①

D4035-043		Manufactured	No		100	Each	2.0000	1			
-----------	--	--------------	----	--	-----	------	--------	---	--	--	--

Lid Rib Assembly, Aft (350 Basket)

Location Loc Qty Loc Code

WA 2

58193 2

100 Each

2.0000 1

CPL 10-05-21

B 58744 → ①

D4086-210		Manufactured	No		140	Each	4.0000	1			
-----------	--	--------------	----	--	-----	------	--------	---	--	--	--

Placard, Max Load

Location Loc Qty Loc Code

ST112 4

56978 4

140 Each

4.0000 1

88 0/05/26 ①

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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3914-041	SHORT BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE
8	1	D4086-210	PLACARD, MAX LOAD

D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION		BY DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3914 REV. A SHEET 1 OF 4 TITLE LONG BASKET LID ASSY (350) NTS	
DRAWN	JPH		
CHECKED	JK		
MFG. APPR.	JK		
APPROVED	JK		
DE APPR.	JK		
DATE	10.03.16		

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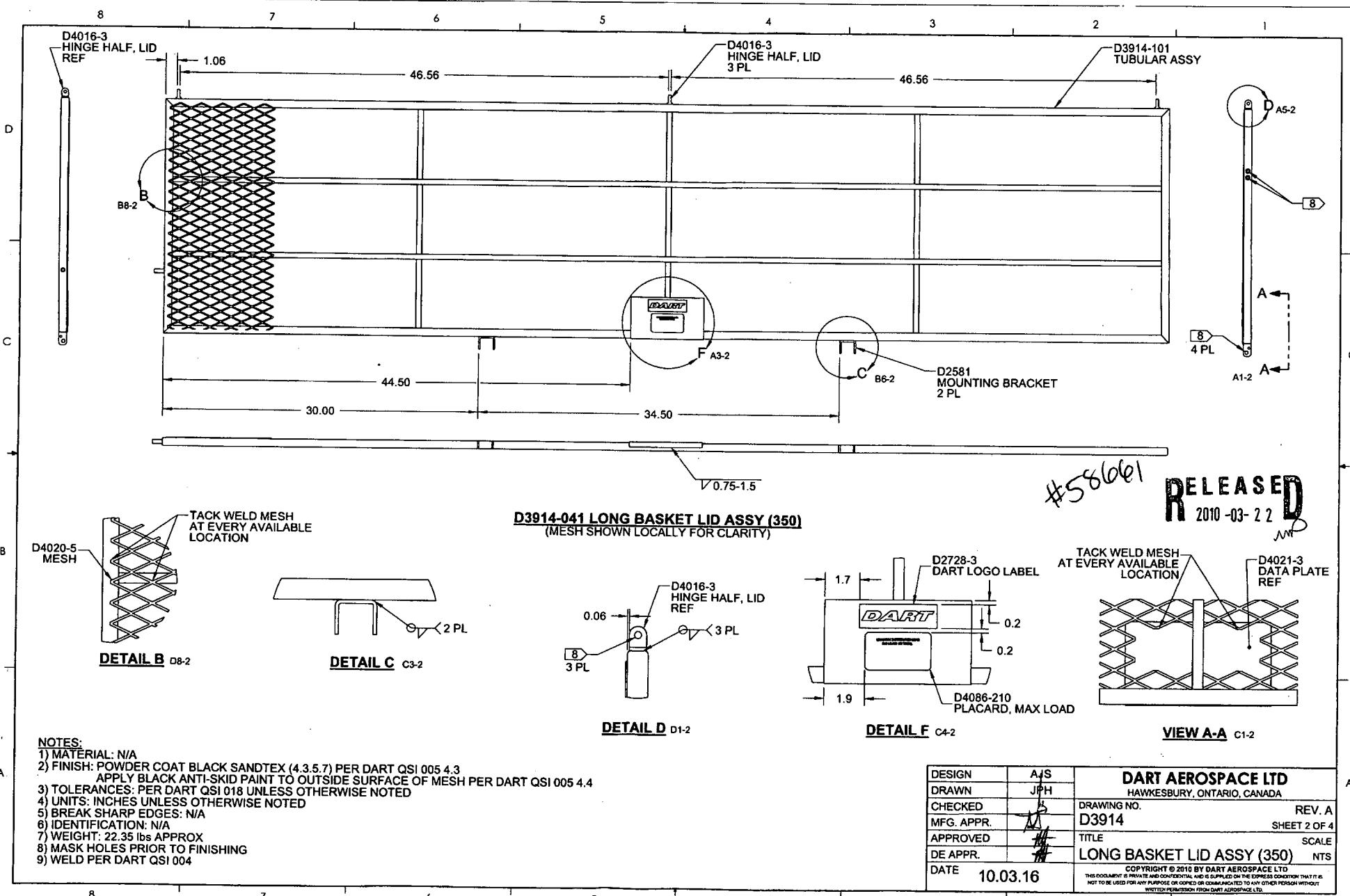
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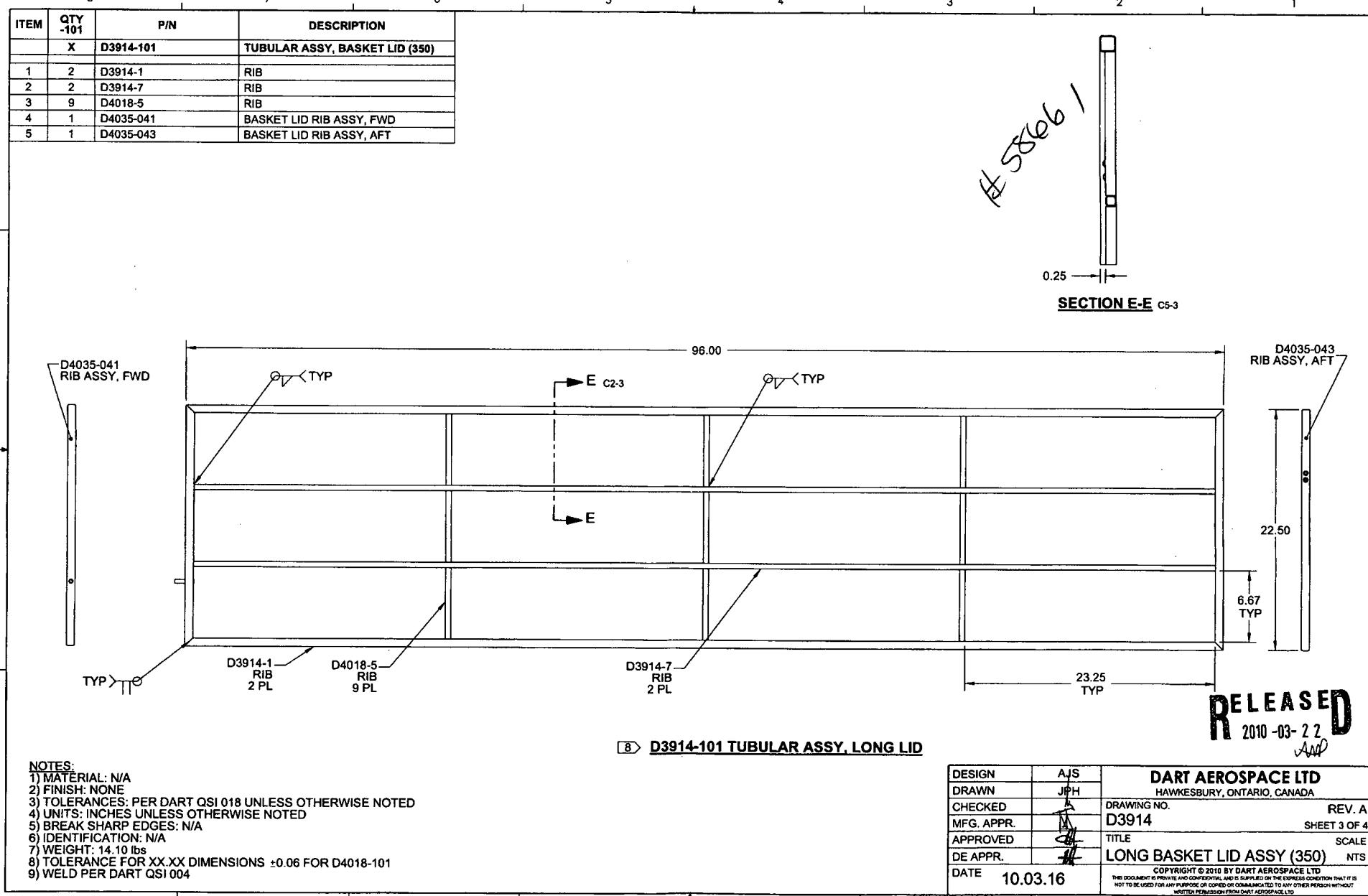


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DESIGN	A/S	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>M</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>M</i>	D3914	SHEET 3 OF 4
APPROVED	<i>M</i>	TITLE	SCALE
DE APPR.	<i>M</i>	LONG BASKET LID ASSY (350) NTS	
DATE	10.03.16	COPRIGHT © 2010 BY DART AEROSPACE LTD	

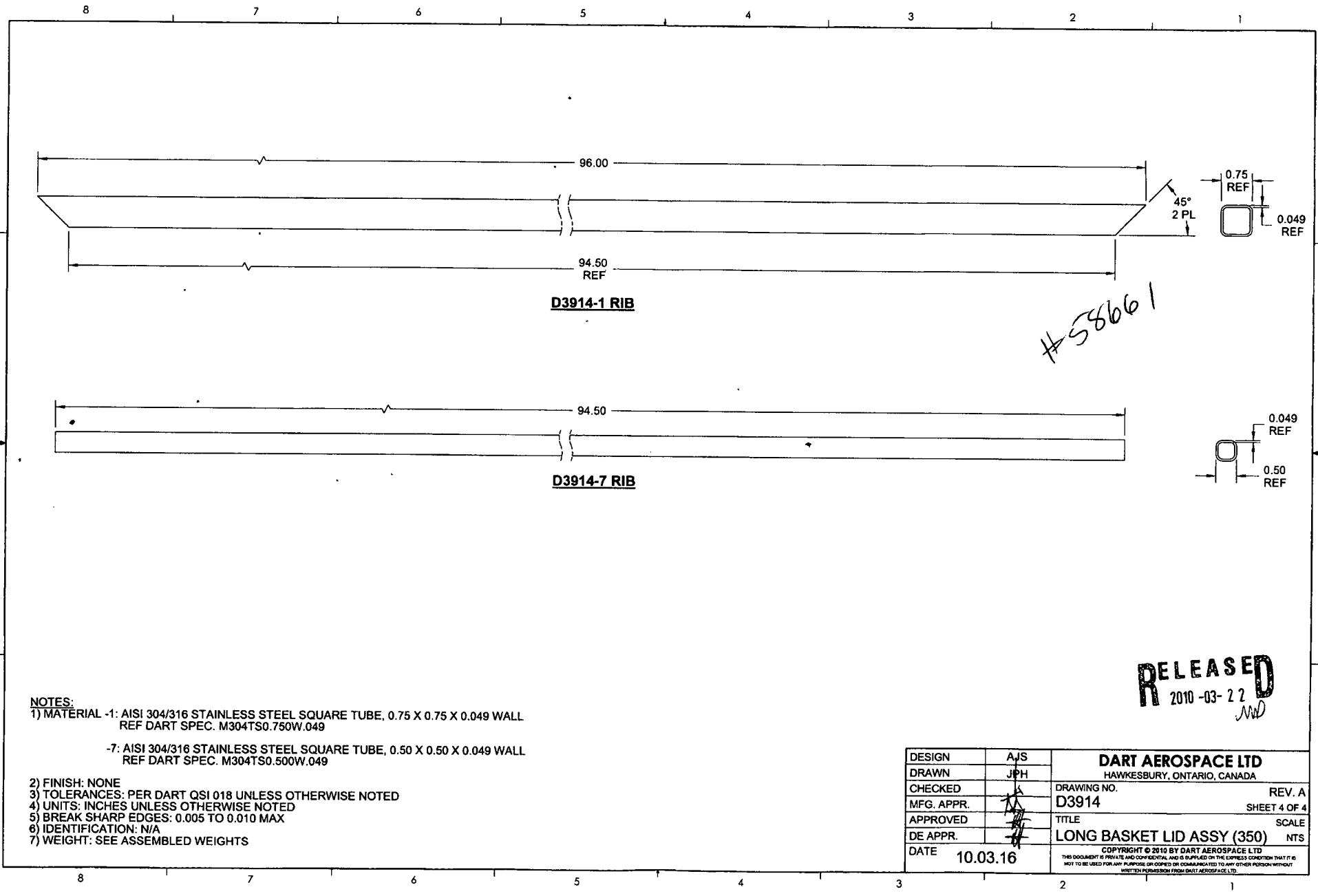
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